



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200
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D2857-1

Job Sheet 212566



Part No: D2857-1

Job Qty: 12 pcs

Part Name: Hinge Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/26/20

Job Tracking No:

Due Date: 9/30/20

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG REV C IPP C 00.06.22 Removed P/O for powder coat EC IPP D

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier		Sign-off
					Setup Hrs Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	12 pcs		9/29/20	0.00 0.42	Bandsaw - 1		SL
110	HAAS 4 Axis - B4B	12 pcs		9/29/20	0.13 6.64	HAAS - 1 - B4B		
						HAAS - 2 - B4B		
						HAAS - 3 - B4B		SL 20-9-16
						HAAS - 4 - B4B		
130	QC 8	12 pcs		9/29/20	0.00 0.00	QC 8 - 12		
						QC 8 - 14		OK 20/09/17
						QC 8 - 17		
						QC 8 - 20		
						QC 8 - 25		
						QC 8 - 3		
						QC 8 - 32		
						QC 8 - 33		
						QC 8 - 35		
						QC 8 - 39		
						QC 8 - 4		
						QC 8 - 44		
						QC 8 - 45		
						QC 8 - 49		
						QC 8 - 58		
						QC 8 - 8		
						QC 8 - 9		
						QC 8 - 68		
						QC 8 - 67		
						QC 8 - 1 (A)		
						QC 8 - 47		
						QC 8 - 40		
						QC 8 - 52		
						QC 8 - 23		
						QC 8 - 57		



Container No: S300642



Part: D2857-1

Job No: 212566

Serial No/Batch: S300642

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
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Email: sales@dartaero.com
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Date: 09/16/20

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140 Handfinish - 1-1 Chemical-B4B	12 pcs	9/29/20	0.00 0.26	QC 8 - 76	
				QC 8 - 61	
				QC 8 - 66	
				QC 8 - 73	
				QC 8 - 82	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
160 Powdercoat - 1 White GI(A)-B4B <i>M 254469.</i> <i>START: 9:00</i> <i>O.V.T. 320°</i> <i>FINISH: 9:30.</i>	12 pcs	9/30/20	0.00 0.18	Powdercoat - 1 - B4B	<i>JT 2020/09/25</i> <i>20-9-25</i>
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
				Powdercoat - 5 - B4B	
				Powdercoat - 6 - B4B	
				Powdercoat - 7 - B4B	
				Powdercoat - 8 - B4B	
				Powdercoat - 9 - B4B	
				Powdercoat - 10 - B4B	
170 QC 3	12 pcs	9/30/20	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	

				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	SEP 2 8 2020
				QC 3 - 19	DAS 40
				QC 3 - 43	9-89
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				QC 3 - 82	
				QC 3 - 87	
				QC 3 - 47	
180	Packaging 3-1 - Stock - B4B	12	9/30/20	0.00 0.00	Packaging 3 - 1 - B4B
		pcs			Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
					Packaging 3 - 37 - B4B

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190 QC 21 - SA

12
pcs

9/30/20

0.00 0.00

QC 21 - SA - 21

21

QC 21 - SA - 70

9-99

SEP 29 2020

Broussard

QC 21 - SA - 9

QC 21 - SA - 77

Part Op 100 - (Bandsaw) Cut blanks 4.425"

Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine per folio FA940 DWG REV: C 2-Deburr any rough edges

130 - (QC8- Inspect parts - second check)

140 - (Chemical Conversion Coat per QSI005 4.1)

160 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ FINISH TIME: _____

170 - (QC3- Inspect Part Finish)

180 - (Identify as per dwg & Stock Location: _____)

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.250X2.000	6061T6 Bar 1.250 X 2.000	4.4400 ft (.37 ea)	100-Bandsaw - 1	S216003 X 12=4.44

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.250X2.000	4	36	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Hinge Bracket	4.300inches ± 0.010	4.310 4.290	4.300	VERW J-2
2	Hinge Bracket	4.000inches ± 0.010	4.010 3.990	4.000	H-G
3	Hinge Bracket	0.340inches ± 0.010	0.350 0.330	.341	VERW J-2
4	Hinge Bracket	1.110inches ± 0.005	1.115 1.105	1.110	-
5	Hinge Bracket	1.790inches ± 0.010	1.800 1.780	1.791	-
6	Hinge Bracket	1.320inches ± 0.005	1.325 1.315	1.320	-
7	Hinge Bracket	2.000inches ± 0.010	2.010 1.990	2.000	-
8	Hinge Bracket	0.340inches ± 0.010	0.350 0.330	.340	-
9	Hinge Bracket	0.447inches ± 0.010	0.457 0.437	.446	H-G
10	Hinge Bracket	0.171inches + 0.005 - 0.000	0.176 0.171	.174	VERW
11	Hinge Bracket	0.147inches ± 0.010	0.157 0.137	.148	-
12	Hinge Bracket	0.376inches ± 0.010	0.386 0.366	.377	-
13	Hinge Bracket	0.126inches ± 0.010	0.136 0.116	.127	-
14	Hinge Bracket	0.063inches ± 0.010	0.073 0.053	.064	-
15	Hinge Bracket	0.166inches + 0.005 - 0.000	0.171 0.166	.168	-
16	Hinge Bracket	0.911inches ± 0.010	0.921 0.901	.912	H-G
17	Hinge Bracket	0.600inches ± 0.010	0.610 0.590	.600	VERW
18	Hinge Bracket	0.125inches ± 0.010	0.135 0.115	.129	-
19	Hinge Bracket	0.150inches ± 0.010	0.160 0.140	.149	-

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					